

Work Order ID 51741

September 1, 2009 8:38:33 AM

Page 1

Item ID: D2989-043

Accept

Revision ID: D

Item Name: Basket Lid Assembly

Start Date: 9/07/09 Start Qty: 1.00

Required Date: 9/18/09 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2989

Rev D

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble all ribs in DT9446 jig, weld as per dwg D2989
2- tack weld mesh on basket as per dwg D2989 using DT9446 jig
3- to locate hinges and shims use D2989-041, weld as per dwg D2989
A/R ER316 S.S. Rod Batch: M109213

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

SL 09/09/08
D 09.09.08

07.09.09

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Page 2

Item ID: D2989-043
Revision ID: D
Item Name: Basket Lid Assembly

Accept



Setup Start



Stop



Start Date: 9/07/09 Start Qty: 1.00
Required Date: 9/18/09 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

⇒ 802/02/09

Ⓟ

φ

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Memo

0.00

Powder Coating

8/10/09/10

xl

φ

1- Plug holes prior to powder coating

2- Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

1112260

1ST COAT

START TIME:

8:45AM

OVEN TEMPERATURE:

400°F

FINISH TIME:

8:15AM

***** 2nd coat if necessary*****

2ND COAT:

START TIME:

10:00PM

OVEN TEMPERATURE:

400°F

FINISH TIME:

10:30AM

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Item ID: D2989-043

Accept

Revision ID: D

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Start Date: 9/07/09 Start Qty: 1.00

Required Date: 9/18/09 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

BL 09-09-11

①

150



Packaging

Packaging

Identify as per dwg & Stock Location: 0.00

Memo

0.00

w/o 51736

BL 09-09-14

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

09/09/15

PL 09-09-14

Picklist Print

September 1, 2009 8:38:32 AM

Page 1

Work Order ID: 51741

Parent Item: D2989-043RevD

Parent Item Name: Basket Lid Assembly


Comments:

Start Date: 9/07/09

Required Date: 9/18/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2221-I RevH		Manufactured	No			100	Each	13.0000	1.0000			
												
Rib												

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

1

48101

1

Main Warehouse

WA

12

51250

12

D2989-3RevD

Manufactured

No

100

Each

5.0000

1.0000



Rib

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

5

48506

1

50572

2

51341

2

① PD 09.09.03

① PD 09.09.03

Picklist Print

September 1, 2009 8:38:33 AM

Work Order ID: 51741

Parent Item: D2989-043RevD

Parent Item Name: Basket Lid Assembly

Comments:

Start Date: 9/07/09

Required Date: 9/18/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2989-4RevD		Manufactured	No			100	Each	5.0000	1.0000			



Rib

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	5	
48503	2	
50573	1	
51342	2	

✓

① PD 09.09.03

D2989-5RevD

Manufactured No

100

Each

8.0000

2.0000



Rib

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	8	
48330	2	
48505	4	
50576	2	

✓

② PD 09.09.03

Picklist Print

September 1, 2009 8:38:33 AM

Work Order ID: 51741

Parent Item: D2989-043RevD

Parent Item Name: Basket Lid Assembly


Comments:

Start Date: 9/07/09

Required Date: 9/18/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3182-1RevA		Manufactured	No			100	Each	14.0000	2.0000			
												
Hinge												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

14

48453

8

51253

6

D3442-3RevA

Manufactured

No

100

Each

10.0000

2.0000



Shim

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

10

42718

1

48504

5

51302

4

2x SY 09/08/08

2x SY 09/09/08

Picklist Print

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Work Order ID: 51741

Parent Item: D2989-043RevD

Parent Item Name: Basket Lid Assembly

Comments:

Start Date: 9/07/09

Required Date: 9/18/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3827-041RevA		Manufactured	No			100	Each	11.0000	1.0000			



Rib Assembly (Inboard)

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

6

51339

6

Main Warehouse

WA

5

51091

5

D3832-5RevA

Manufactured No

100

Each

5.0000

1.0000



Mesh (Lid)

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

5

48216

2

50020

3

① PD 09.09.03

1x SJ 09/09/08

Picklist Print

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Page 5

Work Order ID: 51741

Parent Item: D2989-043RevD

Parent Item Name: Basket Lid Assembly

Start Date: 9/07/09

Required Date: 9/18/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3833-5RevA

Manufactured

No

100

Each

18.0000

2.0000



Mesh (Lid End)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

18

44767

2

51305

16

D3838-041RevA

Manufactured

No

100

Each

5.0000

1.0000



Rib Assembly (Basket Lid, LH)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

5

48502

2

50574

1

51334

2

2x SH 09/09/08

① PD 09.09.03

September 1, 2009 8:38:33 AM

Shop Packet Print

Page 5

Picklist Print

September 1, 2009 8:38:33 AM

Work Order ID: 51741



Parent Item: D2989-043RevD



Parent Item Name: Basket Lid Assembly

Start Date: 9/07/09

Required Date: 9/18/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3838-042RevA		Manufactured	No			100	Each	5.0000	1.0000			



Rib Assembly (Basket Lid, RH)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

5

48501

2

50575

1

51335

2

① PD 09.09.03

D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

RELEASED
08/11/18

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
- 8) WELD PER DART QSI 004

D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-1/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG), D2989-9/-10 (NOW ON D3836 DWG), D2989-1/-2/-7/-15 (NOW ON D3838 DWG) AND D2989-11/-12 (NOW ON D3852 DWG). REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.080 WALL. MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

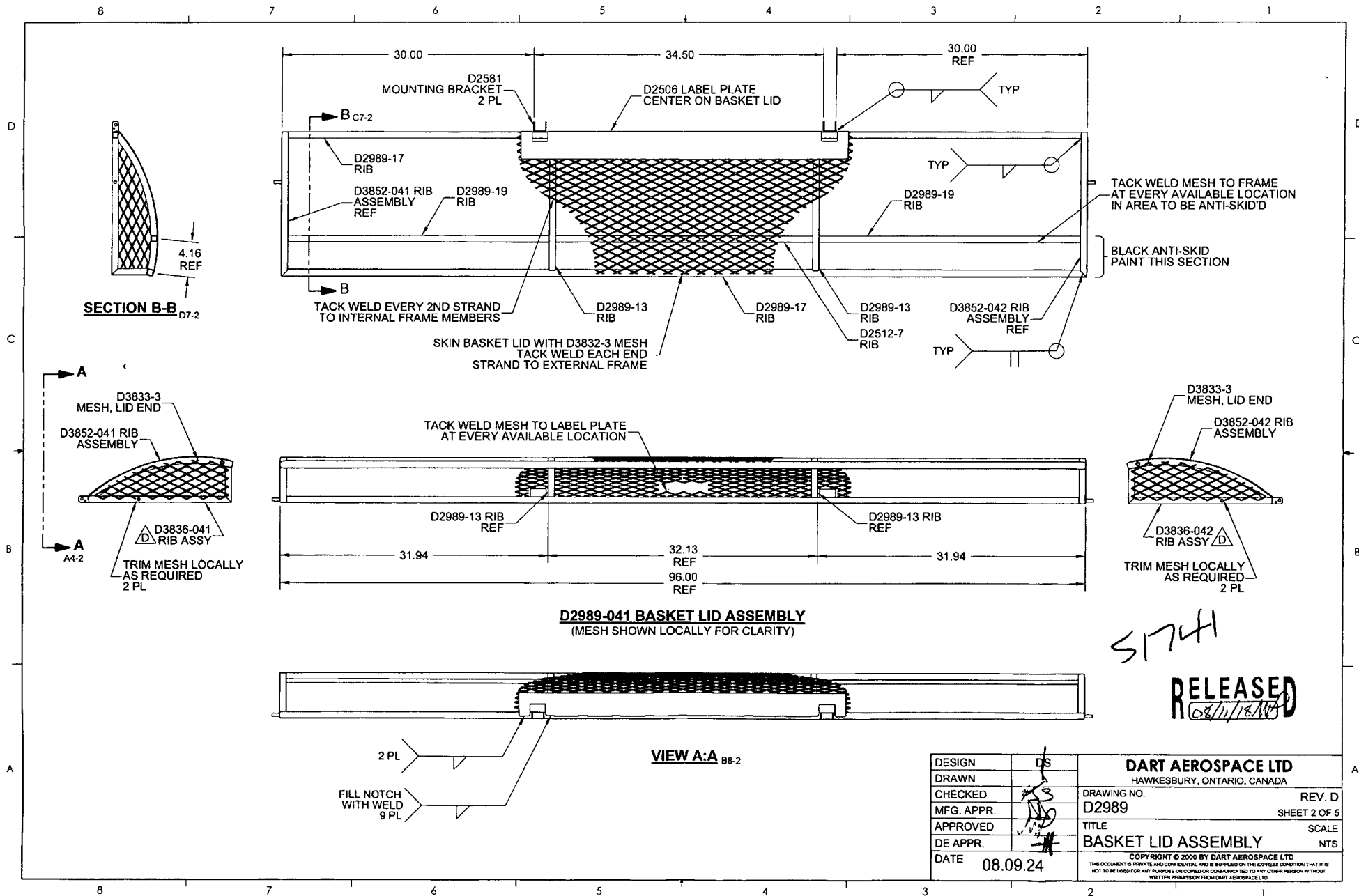
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



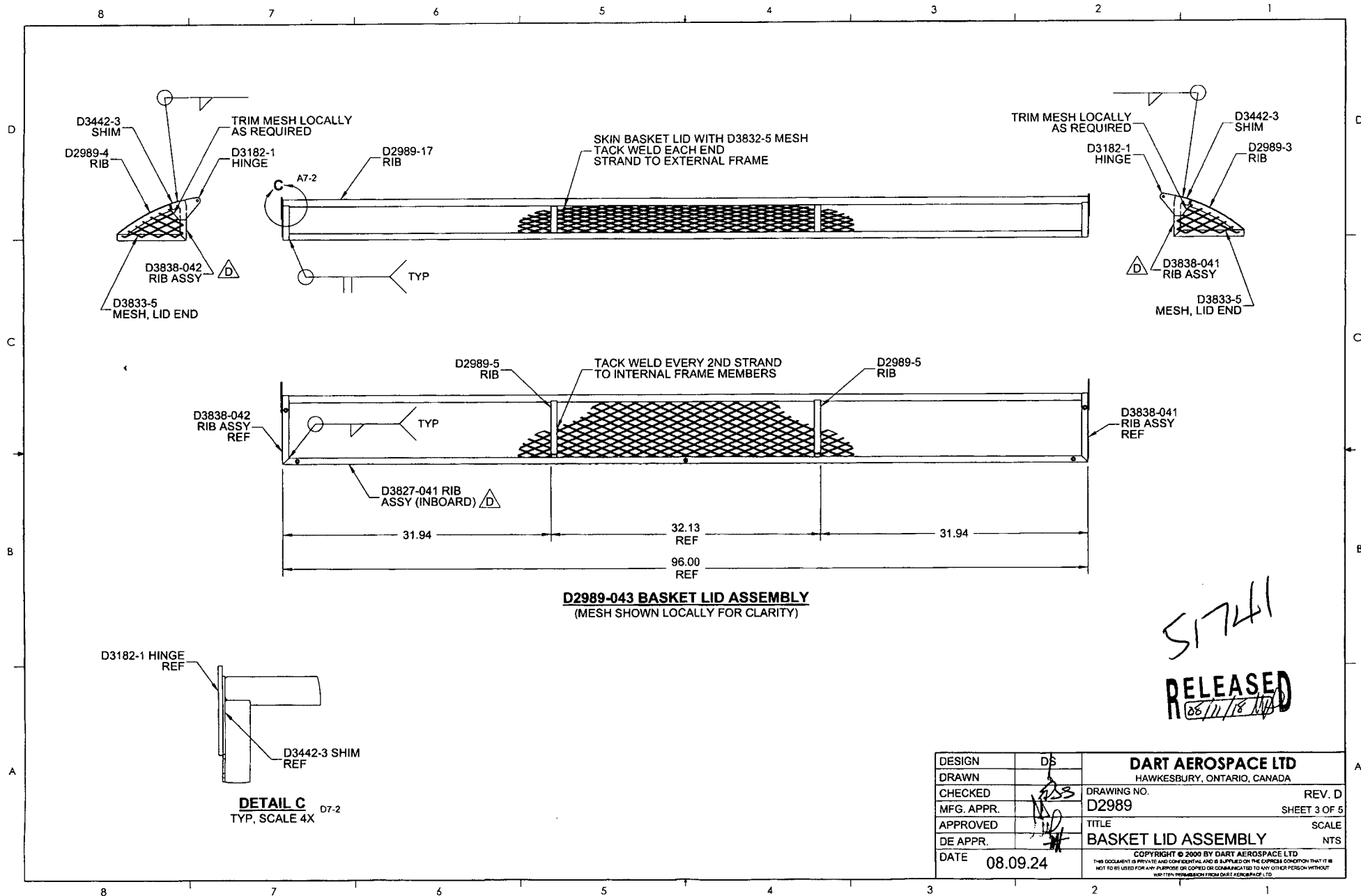
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NOTE: Date & initial all entries



DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 3 OF 5
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DE APPR.		BASKET LID ASSEMBLY	NTS
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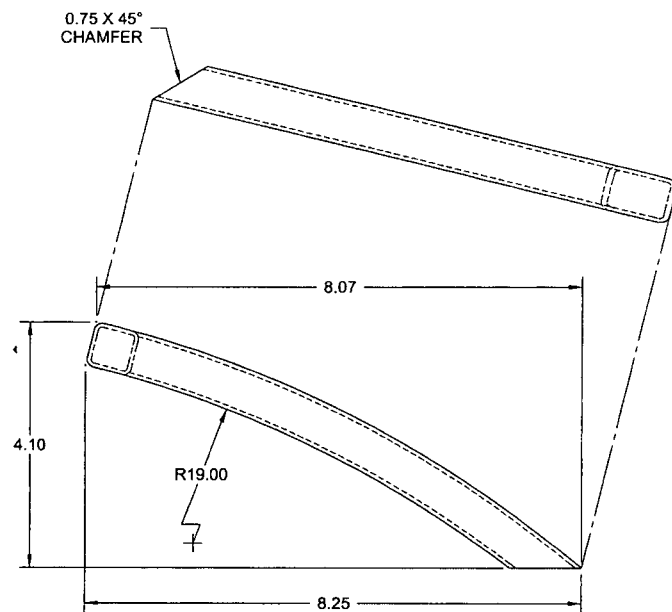
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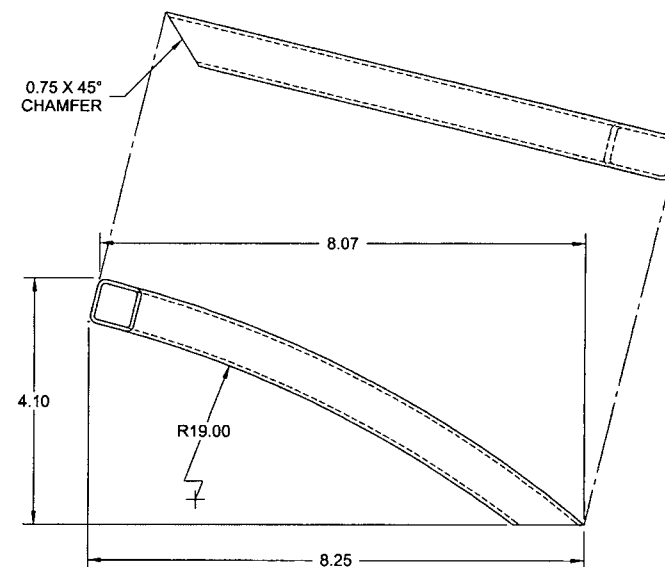
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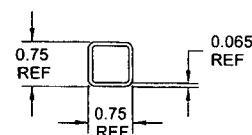
NOTE: Date & initial all entries



D2989-3 RIB






D2989-4 RIB



**TYPICAL SECTION
VIEW**

- NOTES:**
- 1) MATERIAL: D3166-3 BASKET HOOP
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-3/-4 = 0.39 lbs;

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. I
MFG. APPR.		D2989	SHEET 4 OF 5
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DE APPR.		BASKET LID ASSEMBLY	NTS
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RELEASED
08/10/18 NW

51741

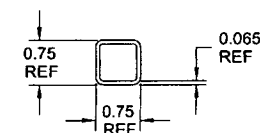
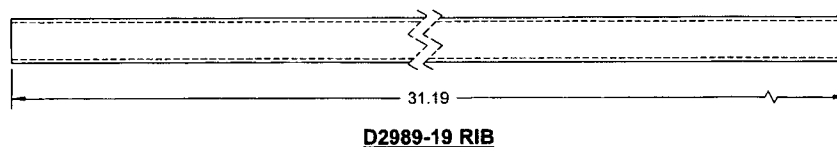
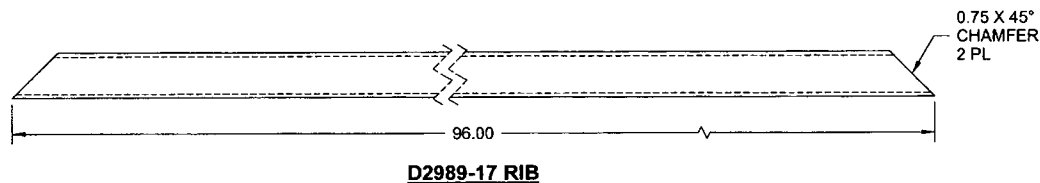
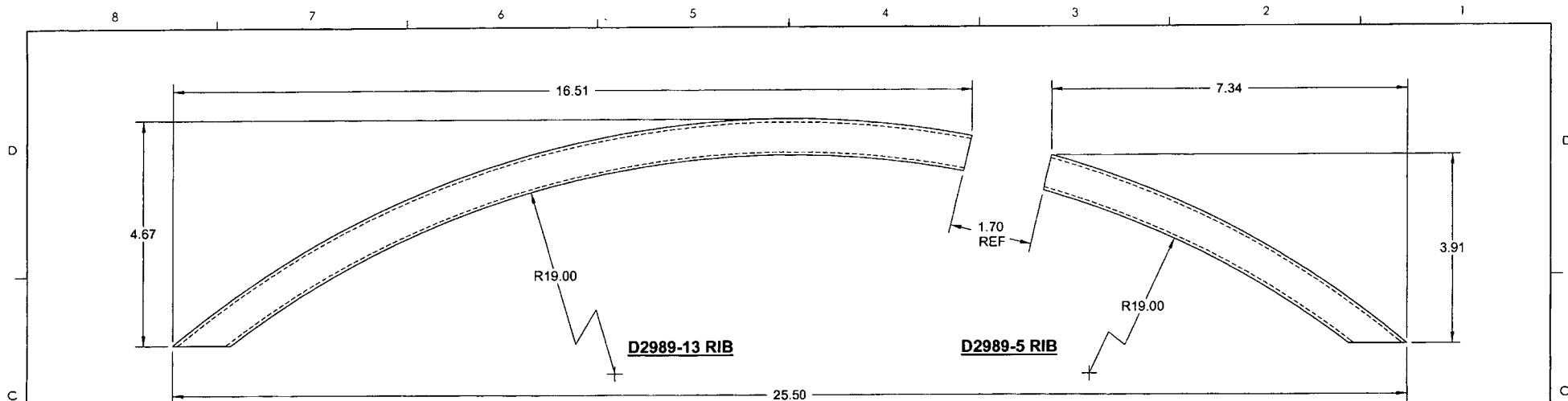
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**TYPICAL SECTION
VIEW**

51741

RELEASED
08/11/18/W

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: D2989-5 = 0.37 lbs; D2989-13 = 0.81 lbs; D2989-17 = 4.57 lbs; D2989-19 = 1.50 lbs

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	SS	DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 5 OF 5
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